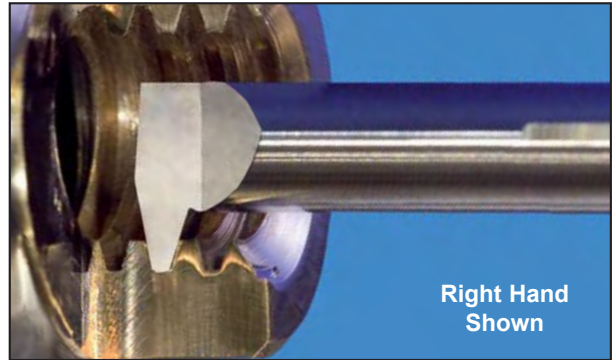


PRODUCT INFORMATION

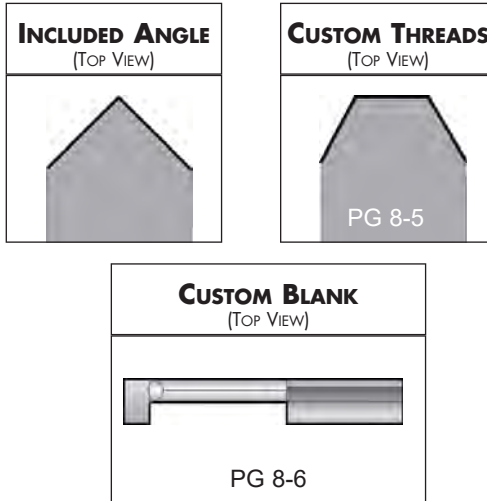
- Internal ACME threading for diameters .187" and larger.
- 6 threads per inch and greater.
- 3/16", 1/4", 5/16" and 3/8".
- Short neck lengths for greater rigidity; long neck lengths for greater reach.
- Elliptically ground necks for greater strength; round necks to fit into small diameters.
- Sub-micron grain **DURA-MAX® 2000** Carbide.
- Tools can be coated with TiN, TiAlN, TiCN and Diamond coating.



Right Hand Shown

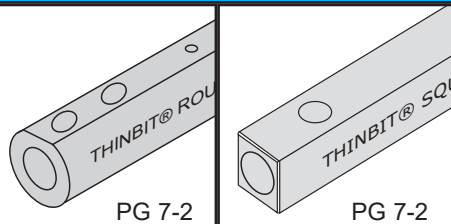
MODIFICATIONS

SEE PAGE
8-3
FOR ADDITIONAL
INFORMATION



TOOLHOLDER SELECTIONS

ADAPTER STYLES



TECHNICAL SECTIONS

PRODUCT DEMONSTRATION



www.thinbit.com/gr4-5

SPEEDS AND FEEDS

PG 9-18

APPLICATION REFERENCE

PG 9-4

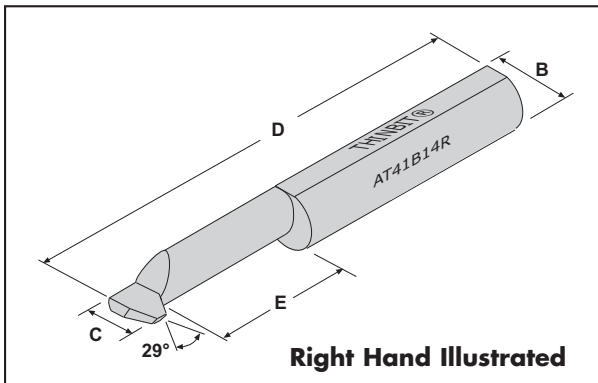
TROUBLESHOOTING

PG 9-7

KAISER TOOL COMPANY, INC.

Phone: 888-THINBIT (888-844-6248) or (260) 484-3620 • Fax: 888-THINFAX (888-844-6329) or (260) 482-1881
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I.D. ACME THREADING TOOLS



FRONT RAKE: Primary 21°

TOP RAKE: 0°

NOTE: Tool designed for feeding into bore only. Right hand tools should be used for right hand internal threads. Left hand tools should be used for left hand internal threads.

- 29° ACME threading inserts for internal and external applications.
- ACME threading tools can be used to cut other thread profiles by over cutting.
- Single lead

ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of tool dimensions.

EXAMPLE:

The **ORDER CODE** for a .250" minimum bore, right hand tool for 14 or fewer T.P.I. and .750" tool reach is:

AT41B14R

I.D. ACME THREADING

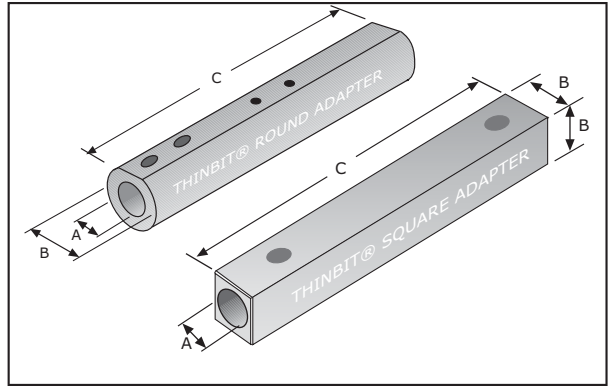
SPECIFICATIONS				ORDER CODE					INFORMATION			
Minimum Bore 'C'	Threads per Inch	Flat at Tip	Tool Reach 'E' Minimum	DURA-MAX® 2000 Carbide See Page 9-18 for Speeds and Feeds information		Coatings See Page 9-6 for Expanded Coating Descriptions Use Uncoated Part Number and Add Coating Code				Overall Length 'D'	Shank Diameter 'B'	Toolholder Page 7-2 Use Toolholders Beginning With
				Right Hand	Left Hand	TiN	TiCN	TiAlN	Diamond			
.187"	16	.021"	.625"	AT31B16R	AT31B16L					1.902"	3/16"	'AD'
.250"	14	.024"	.750"	AT41B14R	AT41B14L					2.413"	1/4"	
.313"	12	.028"	1.000"	AT51B12R	AT51B12L	add 'C'	add 'D'	add 'E'	add 'F'	2.388"	5/16"	
.375"	10	.032"	1.250"	AT61C10R	AT61C10L					2.893"	3/8"	
.375"	6	.057"	1.250"	AT61C06R	AT61C06L					2.863"	3/8"	

KAISER TOOL COMPANY, INC.

ROUND & SQUARE ADAPTERS

PRODUCT INFORMATION

- Designed to adapt round tooling to lathe workholding
- ID sizes 1/8", 5/32", 3/16", 1/4", 5/16" and 3/8".
- Round sizes 1/4", 3/8", 1/2", 5/8" and 3/4".
- Square sizes 5/16", 3/8", 1/2", 5/8", 3/4", 1" and 1-1/4".
- Modifications can be provided on any of our tooling. Please contact us with your application requirements.



TOOL SELECTIONS

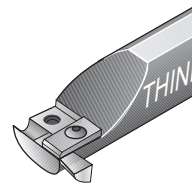
SOLID CARBIDE

- Grooving Page 1-3
- Face Grooving Page 2-3
- Boring Page 3-3
- Threading Page 4-3 & 4-5



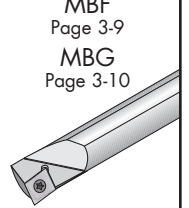
GROOVING BARS

- Grooving Page 1-5
- Face Grooving Page 2-5



BORING BARS

- MBA Page 3-13
- MBB Page 3-15
- MBC Page 3-17
- MBE Page 3-8
- MBF Page 3-9
- MBG Page 3-10



Scan this code for additional information.

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ORDERING INSTRUCTIONS

Select the **ORDER CODE** in the table below that represents your selection of adapter dimensions.

EXAMPLE:

The **ORDER CODE** for a .375" ID x .625" OD round adapter is:

AD3762

SPECIFICATIONS				ORDER CODE				SPECIFICATIONS				ORDER CODE			
Adapter Style	Shank Dimensions			Adapter	Replacement Parts			Adapter Style	Shank Dimensions			Adapter	Replacement Parts		
	'A'	'B'	'C'		Includes Adapter and Hardware	Screw	Wrench		Pin	'A'	'B'		'C'	Includes Adapter and Hardware	Screw
Round	.125"	.250"	3.000"	AD1225	S1402M	W0050	P0203	Round	.312"	.500"	4.000"	AD3150	S1802	W1005	P0204
				AD1237	S1402	W0050	P0203			.625"		AD3162	S1802	W1005	P0206
				AD1250	S1402	W0050	P0204			.750"		AD3175	S1802	W1005	P0206
				AD1262	S1404	W0050	P0204			1.000"		AD3110	S1804	W1005	P0206
				AD1275	S1404	W0050	P0204		.375"	.625"	AD3762	S1802	W1005	P0206	
				AD1210	S1404	W0050	P0204			.750"	AD3775	S1802	W1005	P0206	
	.156"	.375"	3.000"	AD1537	S1402M	W0050	---	Round	.500"	.750"	4.000"	AD3710	S1804	W1005	P0206
				AD1550	S1402	W0050	---					AD5075	S1802	W1005	P0206
				AD1562	S1403	W0050	---					AD5010	S1804	W1005	P0206
	.187"	.375"	3.000"	AD1837	S1402M	W0050	P0203	Round	.750"	1.000"	4.000"	AD7510	S1802	W1005	---
				AD1850	S1802	W1005	P0204								
				AD1862	S1802	W1005	P0206								
				AD1875	S1804	W1005	P0206								
	.250"	.625"	4.000"	AD1810	S1404	W0050	P0206	Square	.250"	.312"	3.000"	AD56	---	---	---
				AD2537	S1402M	W0050	P0203			.375"		AD38	S1802	W1005	---
				AD2550	S1802	W1005	P0204		.250" & .375"	.500"	AD12	S1802	W1005	---	
				AD2562	S1802	W1005	P0206			.625"	AD58	S1802	W1005	---	
				AD2575	S1804	W1005	P0206			.750"	AD34	S1802	W1005	---	
				AD2510	S1804	W1005	P0206			1.000"	AD01	S1802	W1005	---	
									1.250"		AD14	S1802	W1005	---	

TOOLHOLDERS

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